

Date: Thursday, 12/02/2009 11:03:33 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW FRAME
Job Number	: 45769		
Estimate Number	: 13068		
P.O. Number	:	Part Number	: D35433
This Issue	: 12/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3543 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 44652	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 16/02/2009
Checked & Approved By	:	Qty:	4
Comment	: Est Rev:A New Issue 07-11-14 DD verified by:EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 2.6606 sf(s)/Unit Total : 10.6424 sf(s)

Material: 2024T3 sheet 0.063" thick.

Batch 110337

1B 9-2-23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3543

Dwg Rev: 8

Prog Rev: B

1B 9-2-23

(6)

2-Deburr if necessary

1B 9-2-23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 9-2-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 02/02/23 (x6)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FD 02/02/23

(6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/02/2009 11:03:33 AM
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Process Sheet

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Drawing Name: WINDOW FRAME

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



6

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-24

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: _____

09-02-24 (6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

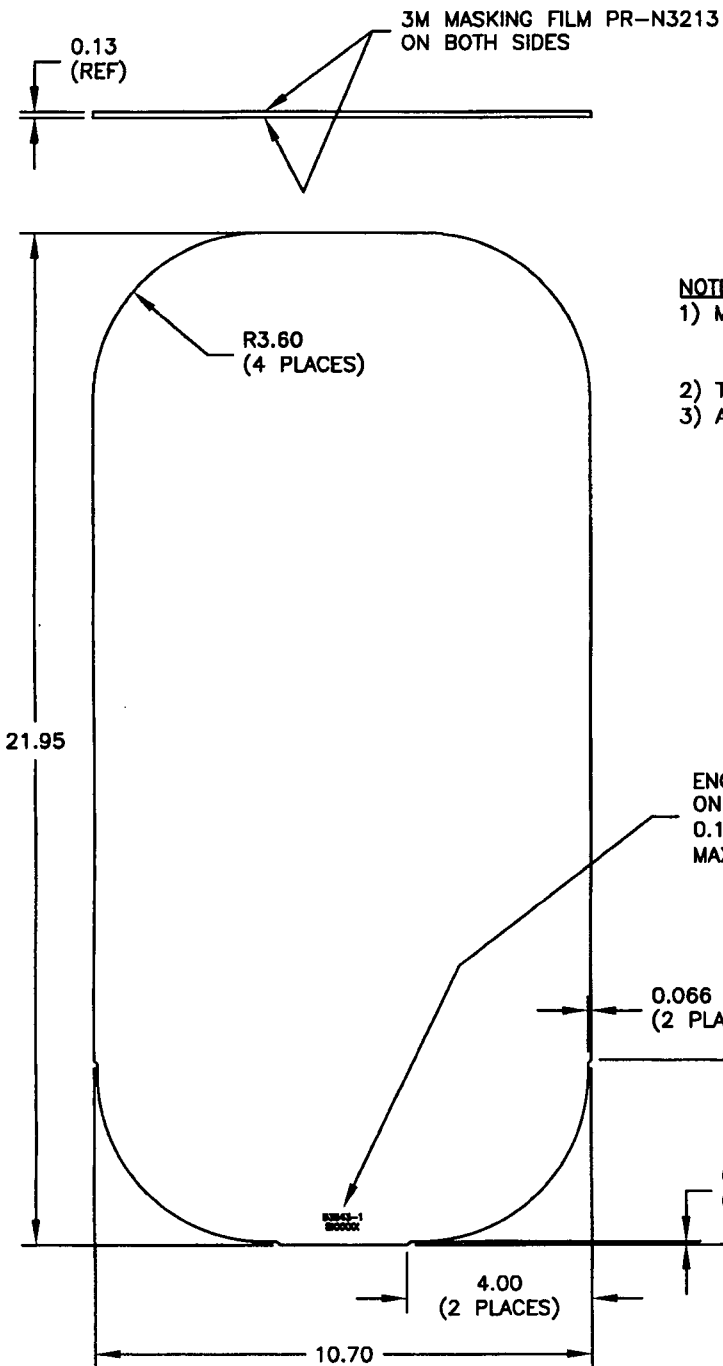
DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA				REV. B	
CHECKED	APPROVED	DRAWING NO.		SHEET 1 OF 2	
06.11.24	06.11.24	D3543		SCALE	
DATE		TITLE		HINGE DOOR PUSH-OUT WINDOW	
06.11.24		NEW ISSUE		1:4	
A		06.08.01		REMOVE D3568-1 PLACARD; D3543-041	
B		06.11.24		ASS'Y NOT REQUIRED ANYMORE	

D3543-1 HINGE PANEL DOOR PUSH-OUT WINDOW

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS "G" CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125" THICK (REF DART SPEC. M-ACRYLIC-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



RELEASED

06.12.12

W045769

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
DATE	06.11.24			D3543	SHEET 2 OF 2
				TITLE	SCALE
				HINGE DOOR PUSH-OUT WINDOW	1:4

RELEASED

06.12.12

D3543-3 HINGE DOOR PUSH-OUT WINDOW FRAME

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK ALUMINUM SHEET
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) IDENTIFY WITH DART P/N D3543-3 & B/N USING FINE POINT PERMANENT MARKER

